



## Rocker Arm Shaft Tightening Procedure on Volvo D9B Engines

The AERA Technical Committee offers the following information regarding a rocker arm shaft tightening procedure on Volvo D9B Engines. The following procedure must be followed correctly or damage to the rockers and shafts could occur.

Listed below is the proper procedure supplied by Volvo. Each step listed below refers to the numbered diagrams.

- Step 1: Tighten bolts 1-7 to 9-13 ft/lbs (12-18 Nm)
- Step 2: Tighten bolts 9, 11, and 13. Begin with bolt 11 and tighten the bolts in steps to make sure that the rocker arm shaft comes down without being bent: 62-70 ft/lbs (85-95 Nm)
- Step 3: Tighten bolts 8, 10, 12 & 14 to 40-48 ft/lbs (55-65 Nm)
- Step 4: Loosen bolts 9, 11 & 13 and re-torque to 40-48 ft/lbs (55-65 Nm)
- Step 5: Angle tighten bolts 1-7 to 85-95°
- Step 6: Angle tighten bolts 8-14 115-125°

